

Work Order ID 129701

February-23-15 10:16:56 AM

129701

Page 1

Item ID: D2281 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Jack Saddle
 Start Date: 2/23/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: MUS Date: 1502-24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2281	Rev G								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2281 Dwg Rev: <u>G</u> Prog Rev: <u>G</u> 2- Debur if necessary								
304.080"									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

30 0 Jm 15-3-6

30 0 Jm 15-3-6

30

DAS
38
9-89
MAR 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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129701

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 Revision ID: Stop ***NS2***
 Item Name: Jack Saddle
 Start Date: 2/23/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 30.00 ***30*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>WAG01</u>	0.00							
160						<u>30</u>		<u>15-03-12</u>	<u>MAL</u>
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170						<u>MLC</u>		<u>15-03-12</u>	
QC	Memo	0.00							
Quality Control									

(Signature) 15-3-12

DQA: _____ Date: _____



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Picklist Print

February-23-15 10:16:56 AM

Page 1

Work Order ID: 129701

129701

Parent Item: D2281

D2281

Parent Item Name: Jack Saddle

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B 06.07.17 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	177.0000	0.125	3.94/367			

M304S14GA

304SS sheet .080

**

4

Jm15-3-6

Location

Loc Qty

Loc Code

MAT019

177

M126075

50

M129972

127

129972

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	129701
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.468"	-		✓	Initial
4.114	+/-0.010	4.116"	-		✓	
2.933	+/-0.010	2.935"	-		✓	
1.535	+/-0.010	1.541"	-		✓	
0.354	+/-0.010	0.356"	-		✓	
0.354	+/-0.010	0.357"	-		✓	
0.604	+/-0.010	0.607"	-		✓	
2.000	+/-0.010	2.003"	-		✓	
3.396	+/-0.010	3.396"	-		✓	
3.646	+/-0.010	3.647"	-		✓	
4.000	+/-0.010	4.005"	-		✓	
1.525	+/-0.010	1.527"	-		✓	
2.475	+/-0.010	2.476"	-		✓	
Ø0.323	+0.006/-0.001	0.324"	✓		✓	
0.080	+/-0.010	0.076"	-		✓	

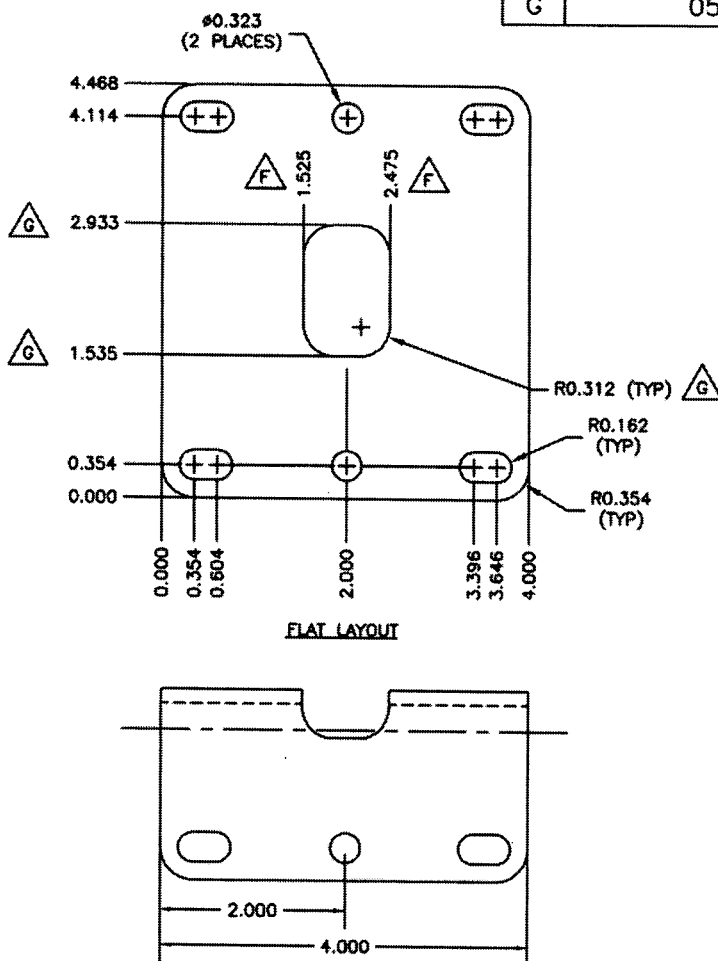
Measured by: Jm	Audited by: DAE 38 9-89	Prototype Approval:	N/A
Date: 15-3-6	Date: MAR 09 2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	

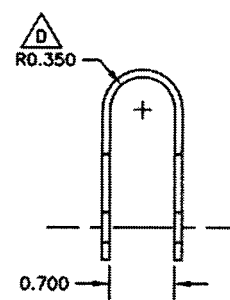


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2	
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
05/08/11



129701 mcs
4-20-05



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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